

Work Order ID 145731 - 2.12

145731

Friday, May 06, 2016 10:44:07 AM

Page 1

Item ID: D350-567-141

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Floor Window Close Out

Stop *NS2*

Start Date: 5/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: pm Date: 16/05/09

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS
27
9-89
JUN 17 2016

DAS
28
9-89
MAY 31 2016

DAS
27
9-89

JUN 17 2016

Work Order ID 145731

Friday, May 06, 2016 10:44:07 AM

145731

Page 2

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Window Close Out

Stop

NS2

Start Date: 5/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-567-141
Location:FG033

Sold

DAS
27
68-6
82
SVD

JUN 17 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.20

MLJ

JUN 17 2016

u 160617

Picklist Print

Friday, May 06, 2016 10:44:06 AM

Page 1

Work Order ID: 145731

145731

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD VERF:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4434-047		Manufactured	No				Each	0.0000		2			
-----------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D4434-047

Cover Assembly

D3802-1

D3802-1

Windows Seal (\$ Per Foot)

Location

Loc Qty

Loc Code

ST416

44.13776

134091

0.75

140492

1

141991

5.88776

143804

36.5

D4434-041		Manufactured	No			110	Each	0.0000	1	2			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4434-041

Fwd Bracket Assembly

D4435-045

D4435-045

T/R Bellcrank Cover Assembly

D4435-9

D4435-9

Bracket

Location

Loc Qty

Loc Code

ST098

4

138369

4

JUN 09 2016

JUN 15 2016

JUN 09 2016

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Page 2

Work Order ID: 145731

145731

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

D4436-041

Manufactured No

110 Each 0.0000

1 2

D4436-041

Aft Bracket Assembly

**

113 937

DAS 28 9-89

D4441-1

Manufactured No

110 f 433.6130

2 4

D4441-1

Rubber Seal

**

Location

Loc Qty

Loc Code

ST422

433.613

120932

433.613

AN3-3A

Purchased No

110 Each 184.0000

7 14

AN3-3A

Bolt

**

Location

Loc Qty

Loc Code

ST350

184

m134294

2

m134537

82

m134654

100

AN525-10R6

Purchased No

110 Each 380.0000

2 4

AN525-10R6

Screw

**

Location

Loc Qty

Loc Code

ST329

380

M134502

380

MAY 31 2016

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Page 2

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Parent Item Name: Floor Window Close Out

145731

D350-567-141

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

AN525-832R7

Purchased

No

110

Each

152.0000

2

4

AN525-832R7

Screw

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

71

m134070

71

ST328

81

m131957

6

m134070

75

4

MS21042L06

Purchased

No

110

Each

211.0000

7

14

MS21042L06

Nut

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

211

m134294

61

m134474

50

m134537

100

14

MS21042L08

Purchased

No

110

Each

1,195.000

2

4

MS21042L08

Nut

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

319

m133134

3

m134063

316

ST303

619

m129682

82

m133922

37

m134574

200

m134654

300

ST308

257

m134376

257

4

JUN 17 2016

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Page 5

Work Order ID: 145731

145731

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 5/11/2016

Required Date: 5/24/2016

Start Qty: 2.00

Required Qty: 2.00

MS35206-229

Purchased

No

110

Each

137.0000

7

14

MS35206-229

Screw

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST271

137

M134070

137

NAS1149F0332P

Purchased

No

110

Each

3,408.000

12

24

NAS1149F0332P

Washer

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

3096

m134257

1096

m134676

2000

NAS1149FN616P

Purchased

No

110

Each

66.0000

14

28

NAS1149FN616P

WASHER

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST263

66

M133988

66

NAS1149FN816P

Purchased

No

110

Each

762.0000

2

4

NAS1149FN816P

WASHER

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

762

117316

762

MAY 31 2016

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Page 5

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 2 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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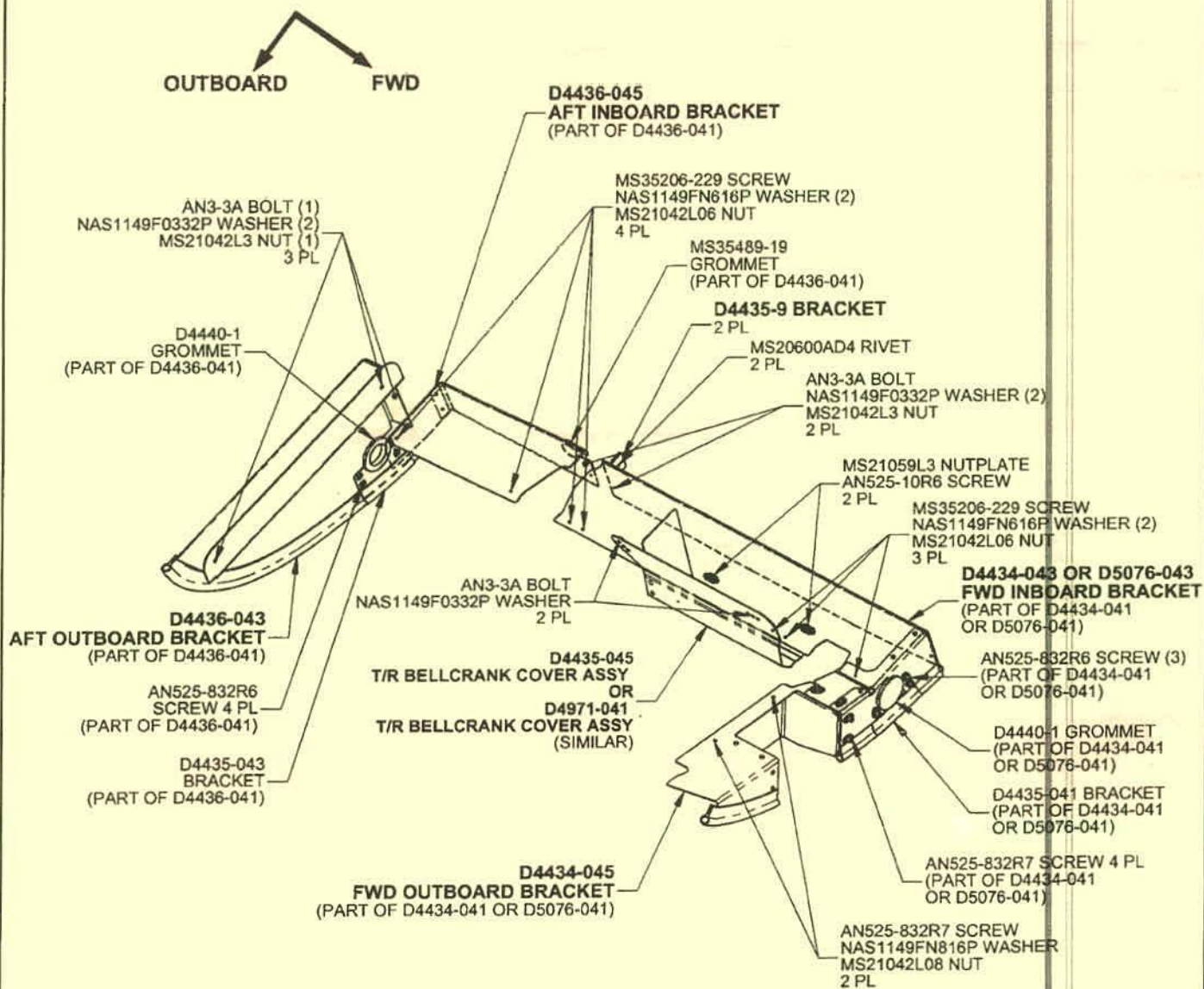


Figure 2. Floor Window Close-out Kit Installation

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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill $2 \times \varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill $2 \times \varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill $2 \times \varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill $2 \times \varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill $2 \times \varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill $2 \times \varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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D. SHEPHERD (DE # 02)

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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Transfer drill 2 x $\phi 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\phi 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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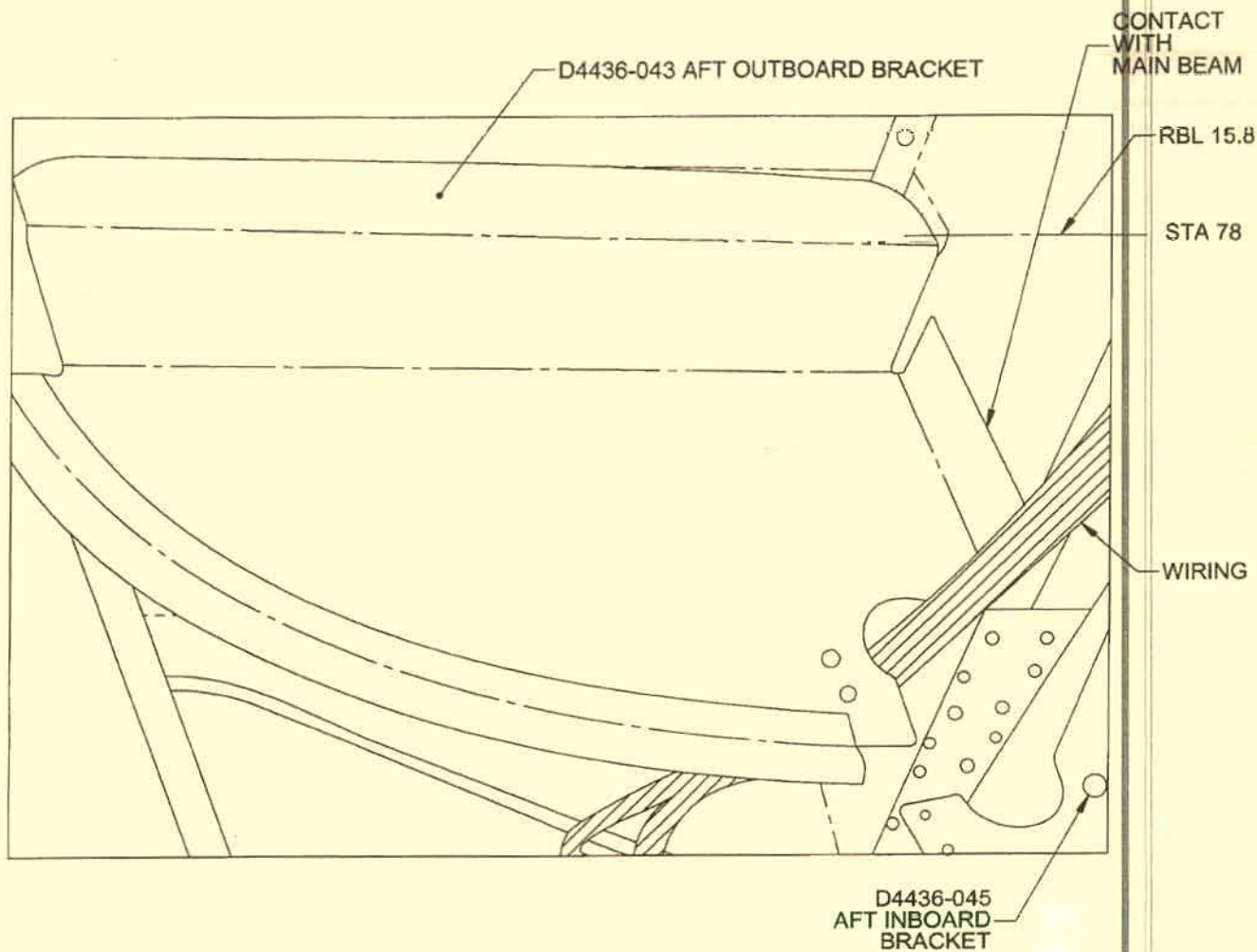


Figure 3. D4436-043 Aft Outboard Bracket Installation

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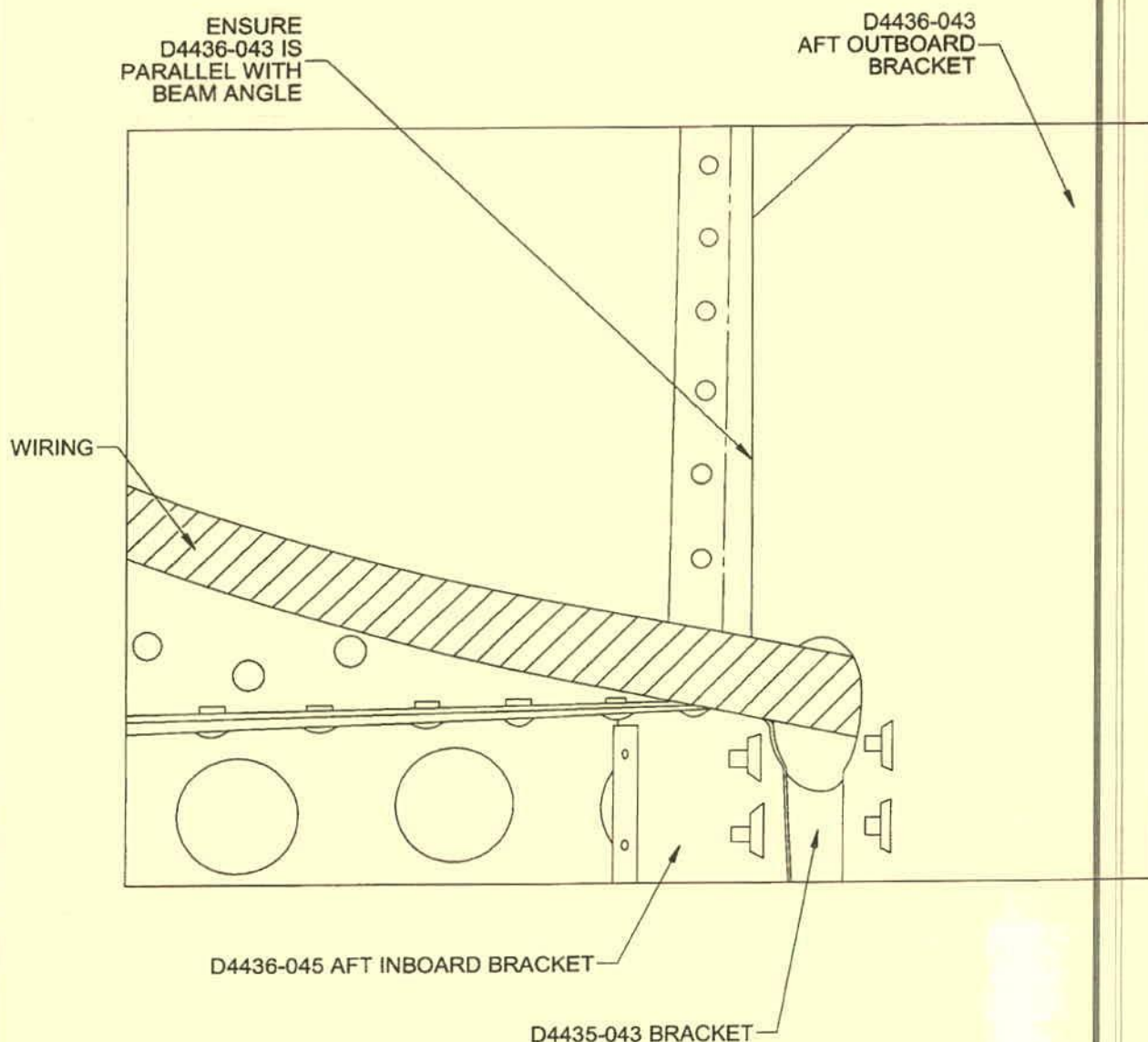


Figure 4. D4436-043 & D4435-043 Brackets Installation

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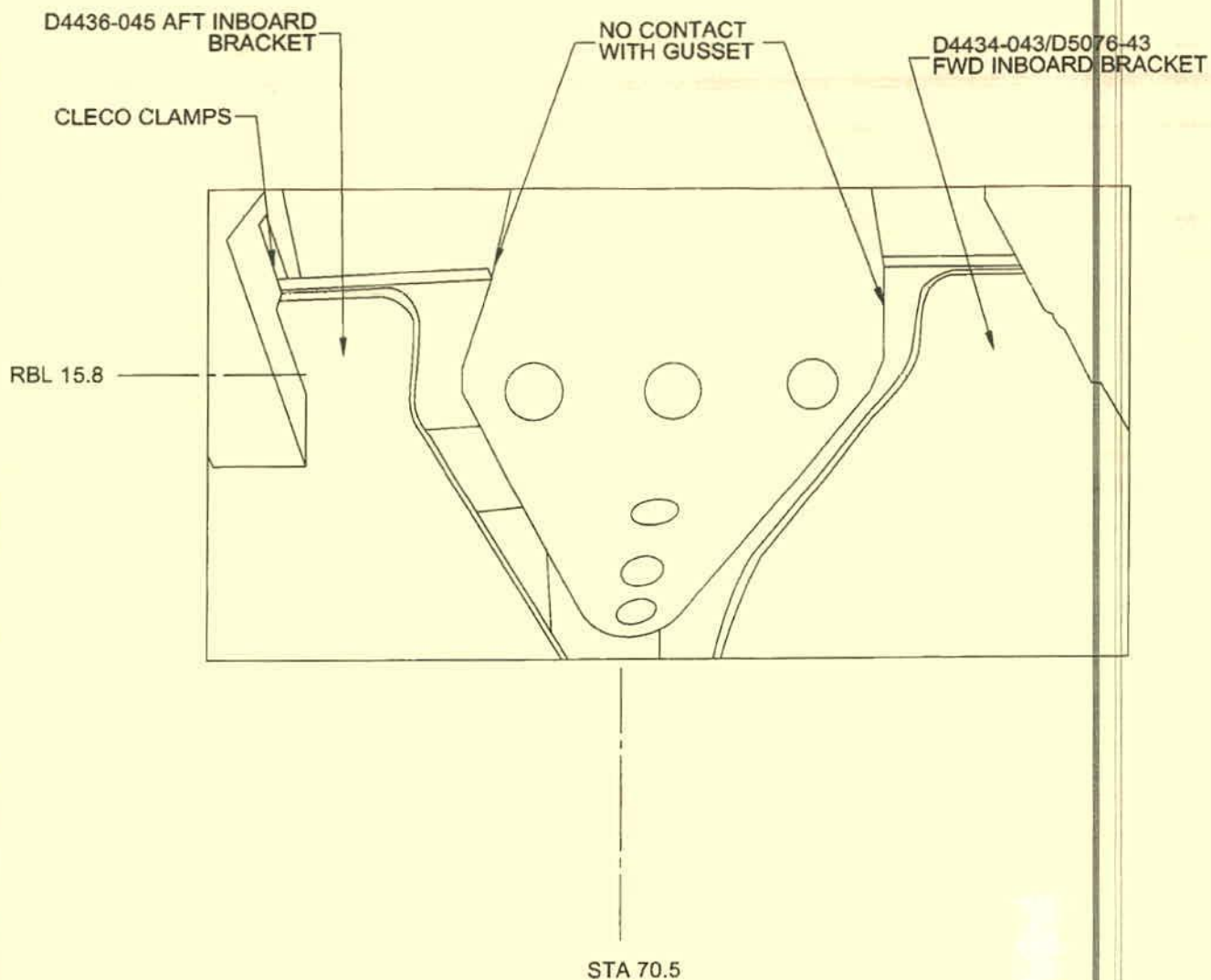


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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MFG. APPR.	N/A	DSI 9590	SHEET 8 OF 19
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DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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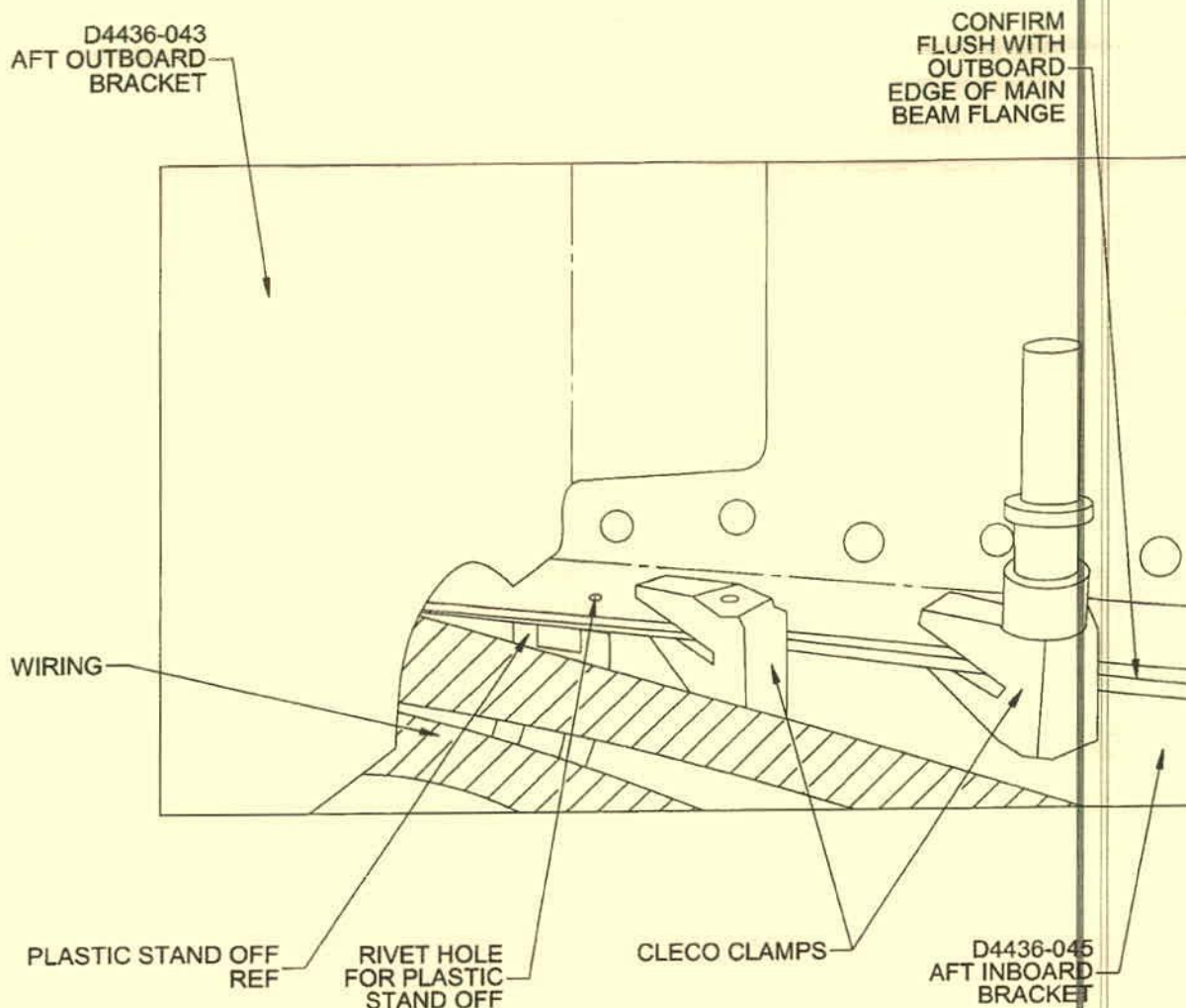


Figure 6. D4436-043 & D4436-045 Brackets Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 9 OF 19
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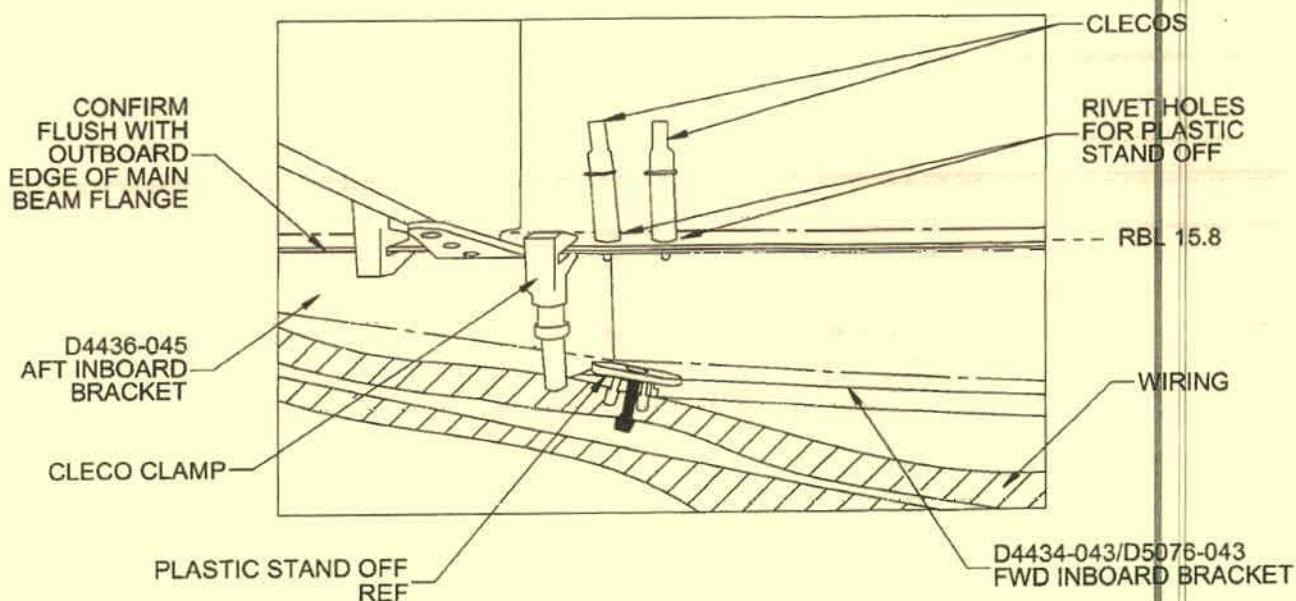


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

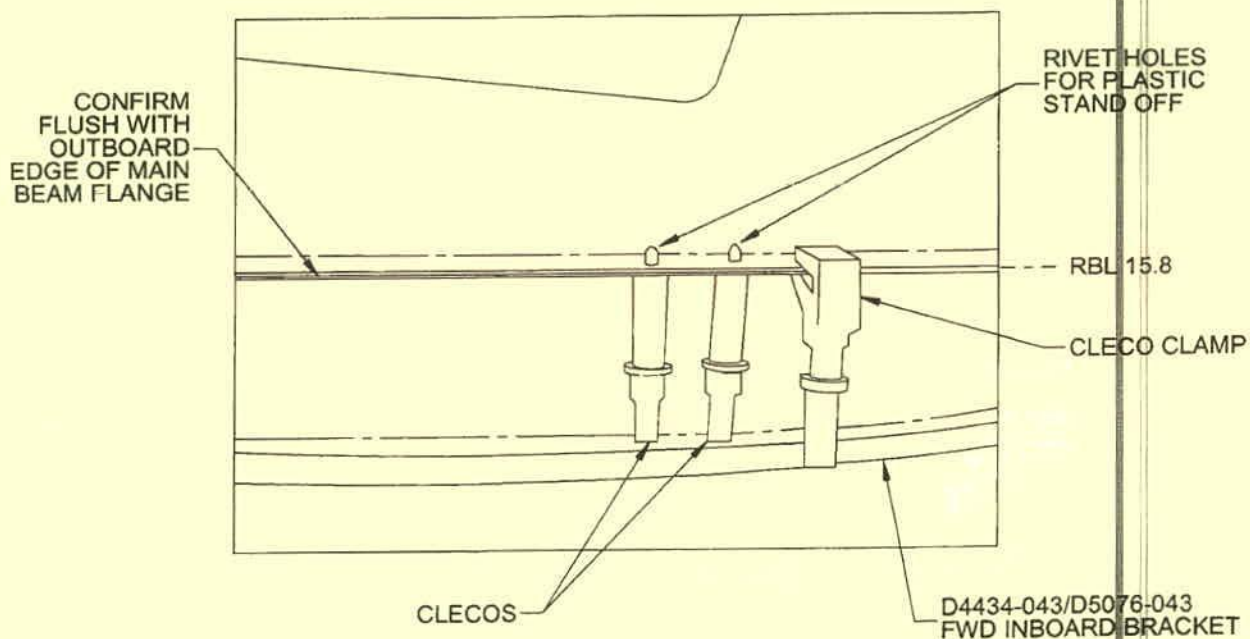


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 10 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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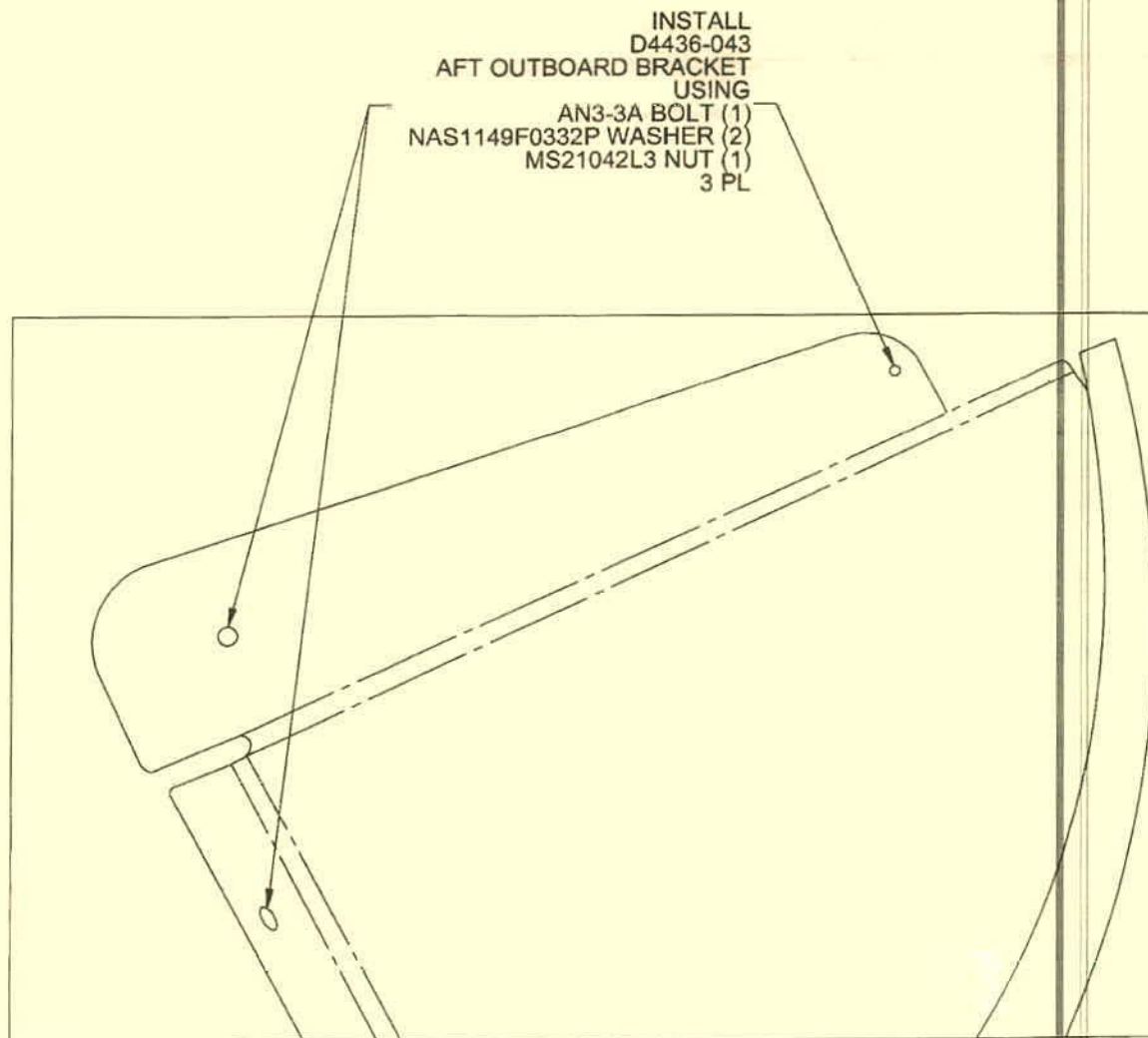


Figure 9. D4436-043 Aft Outboard Bracket Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

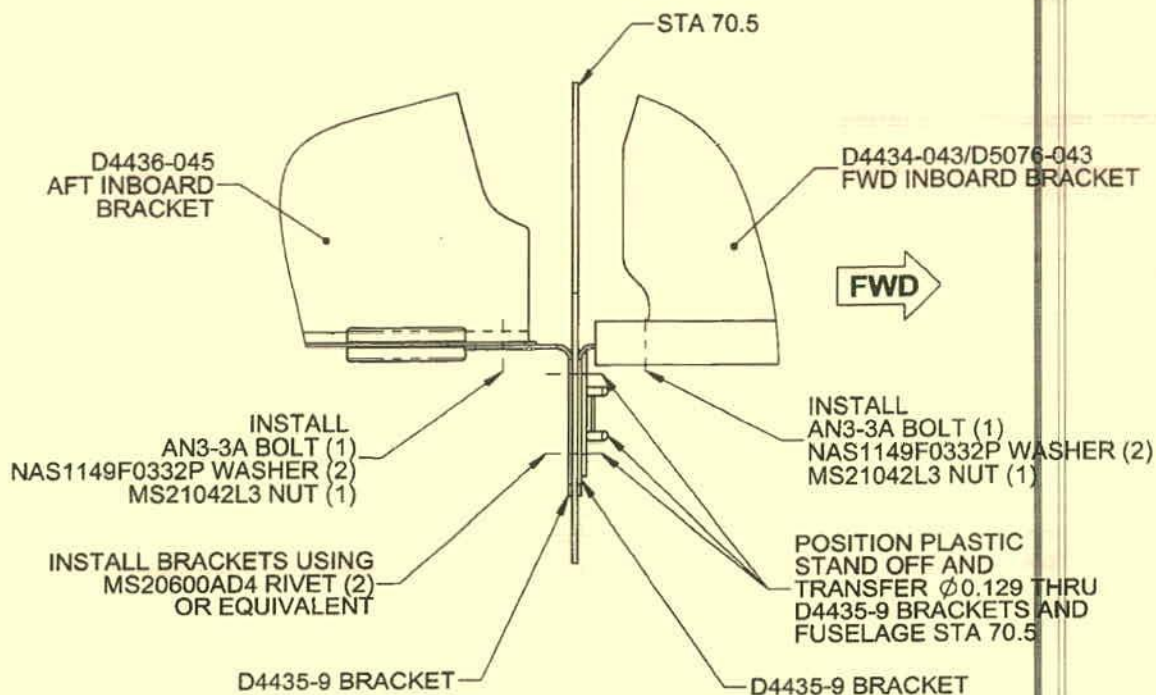
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BY:

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 11 OF 19	
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LOOKING UP AT STA 70.5

D4434-043/D5076-043
FWD INBOARD BRACKET

PLASTIC STAND OFF
REF

Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

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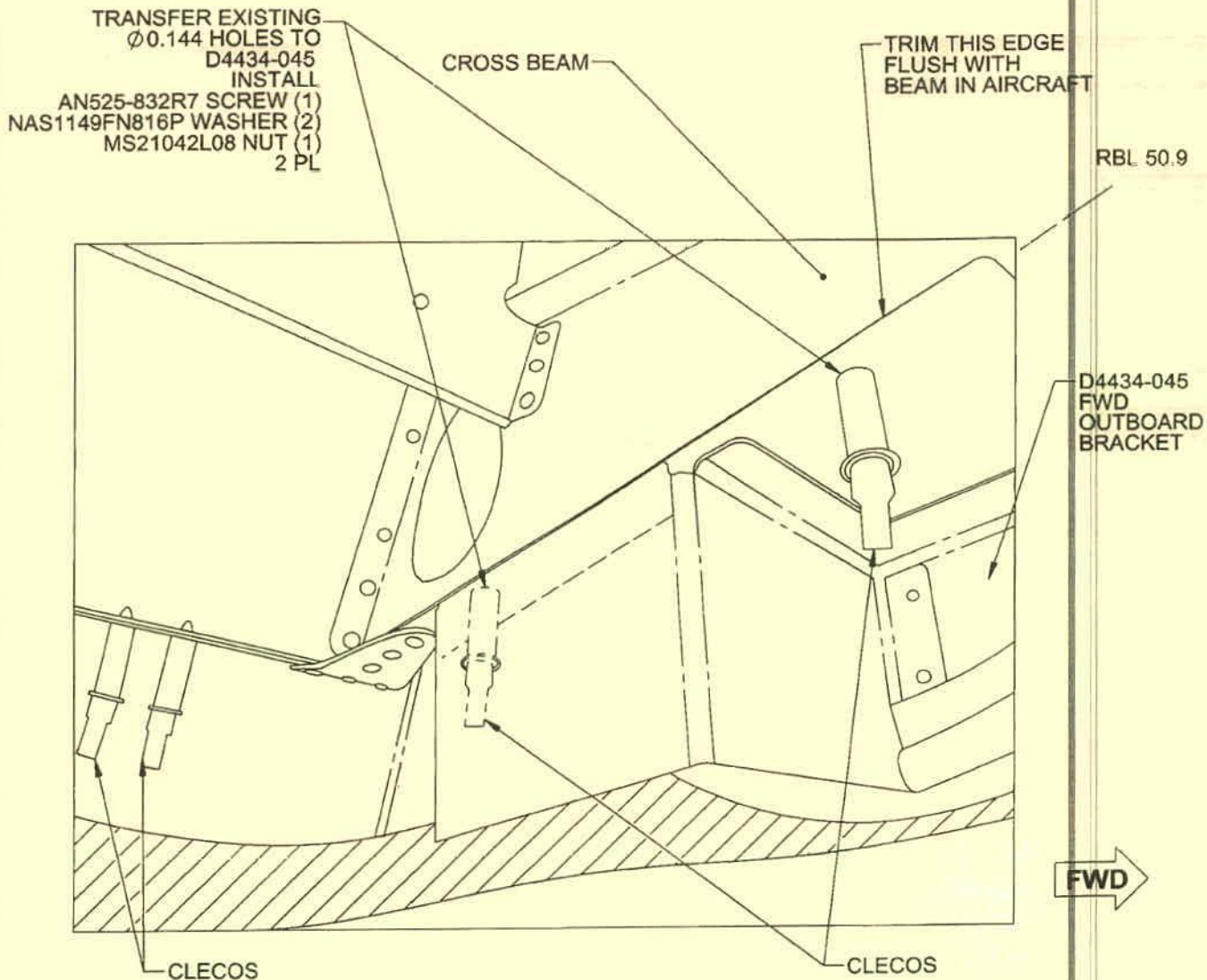


Figure 11. D4434-045 Bracket Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 13 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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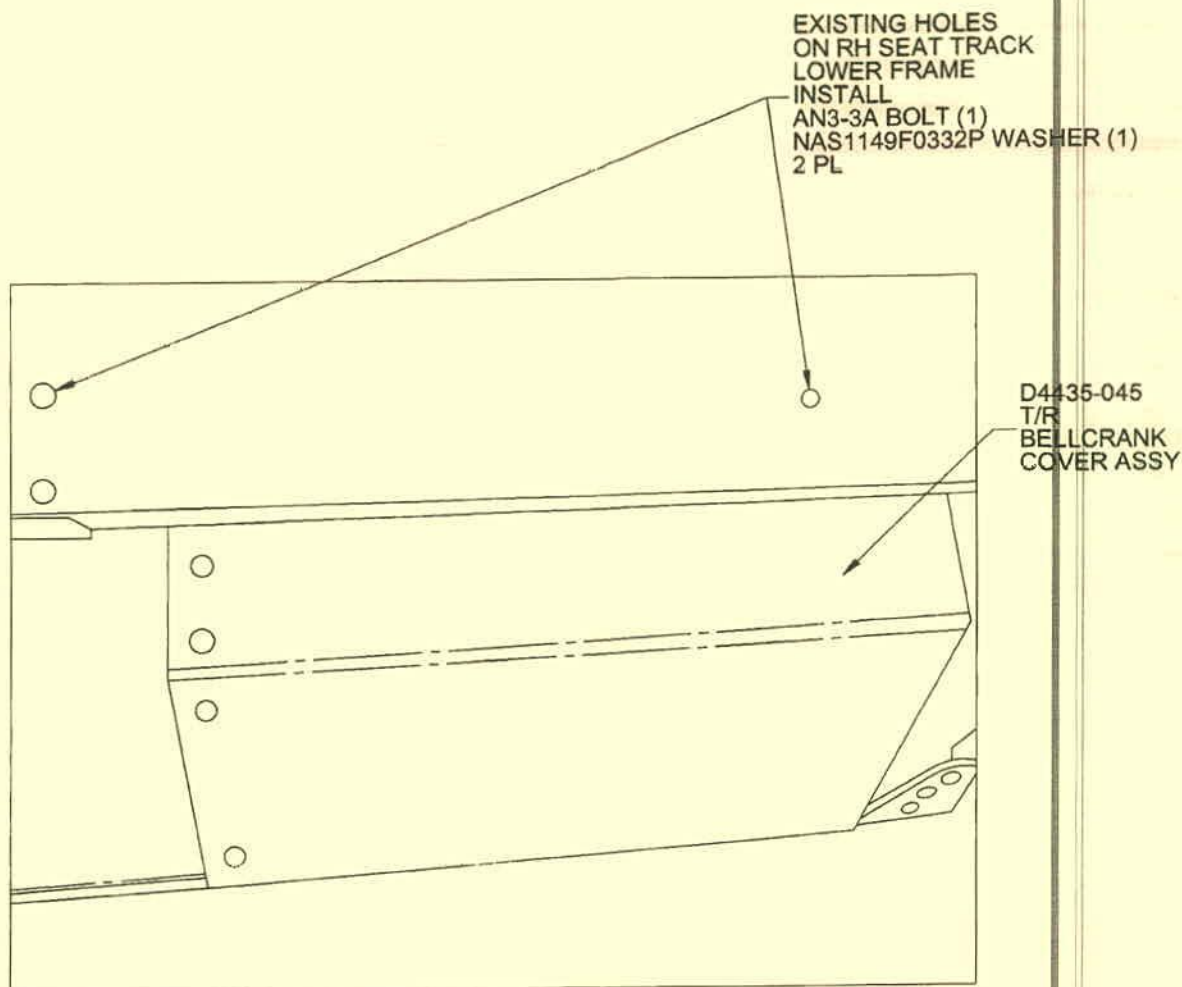


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 14 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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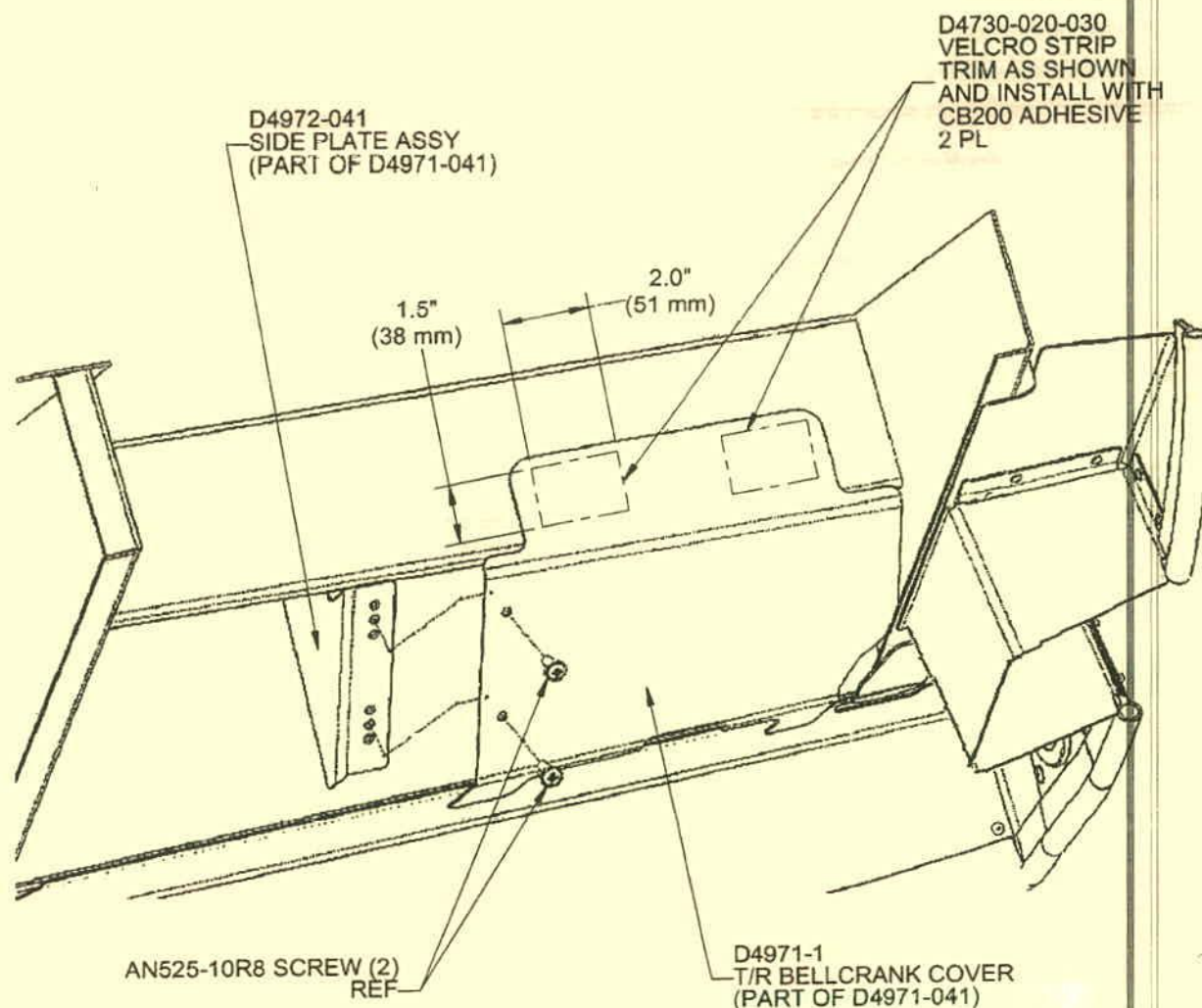


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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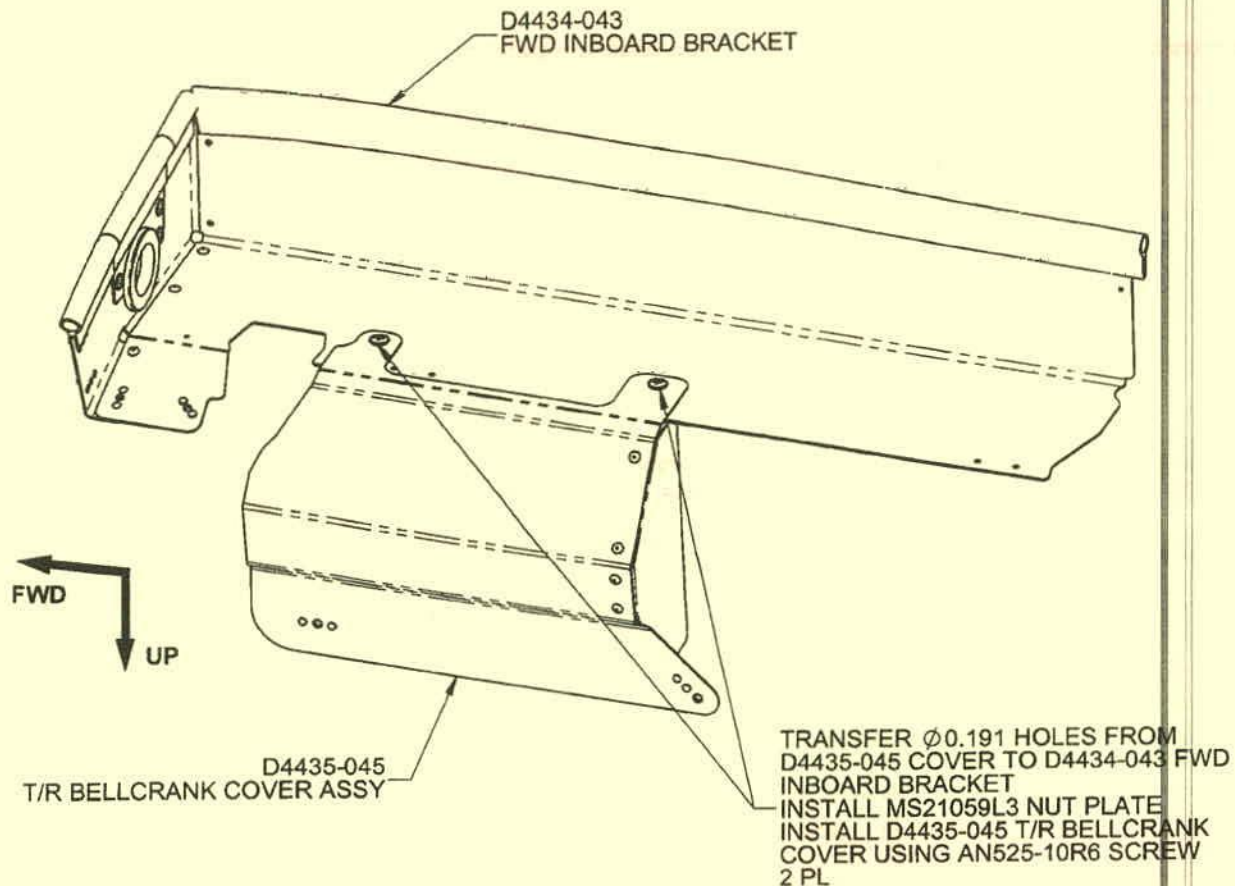


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 16 OF 19	
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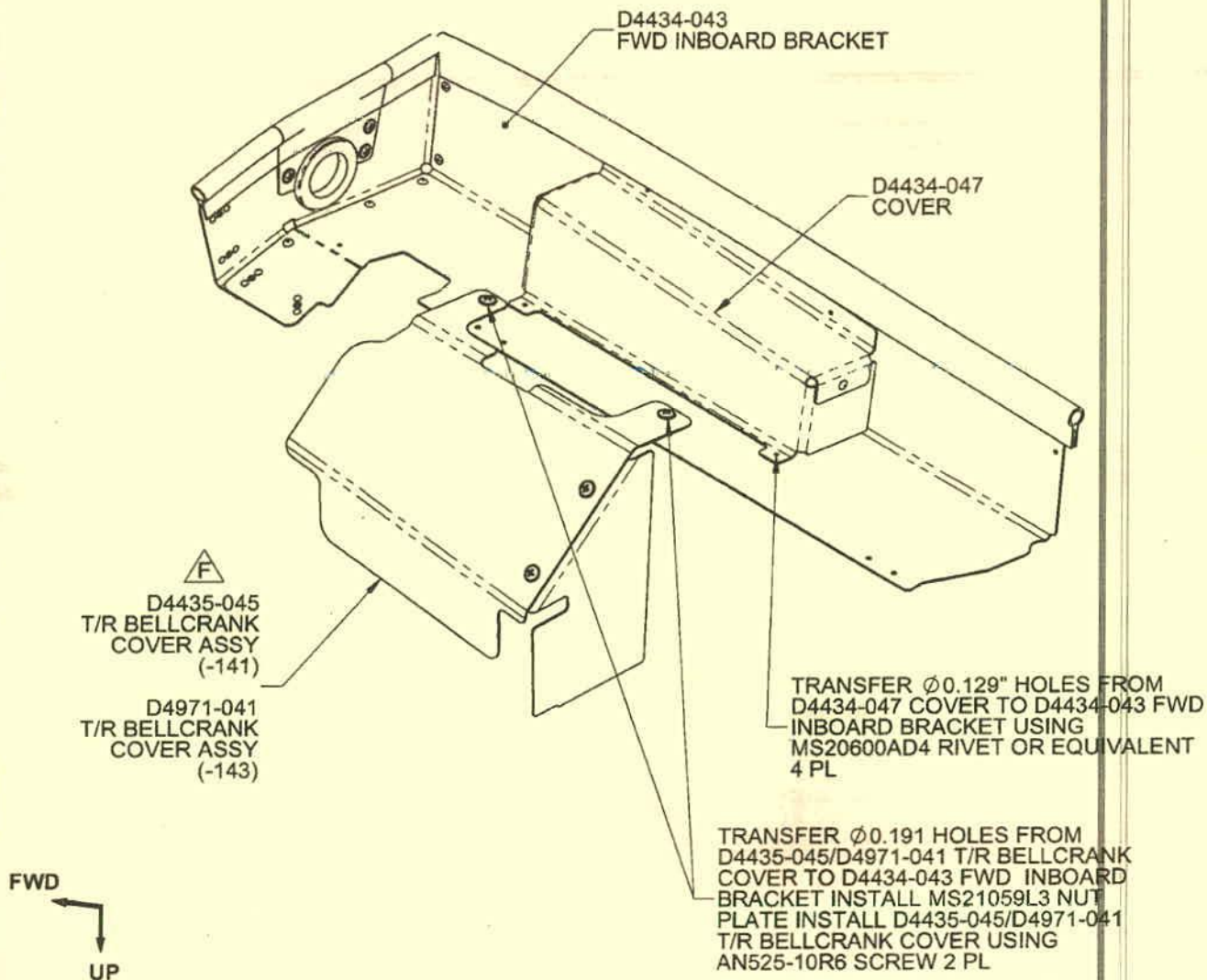


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation △
(D4434-047 is Optional on -141)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 17 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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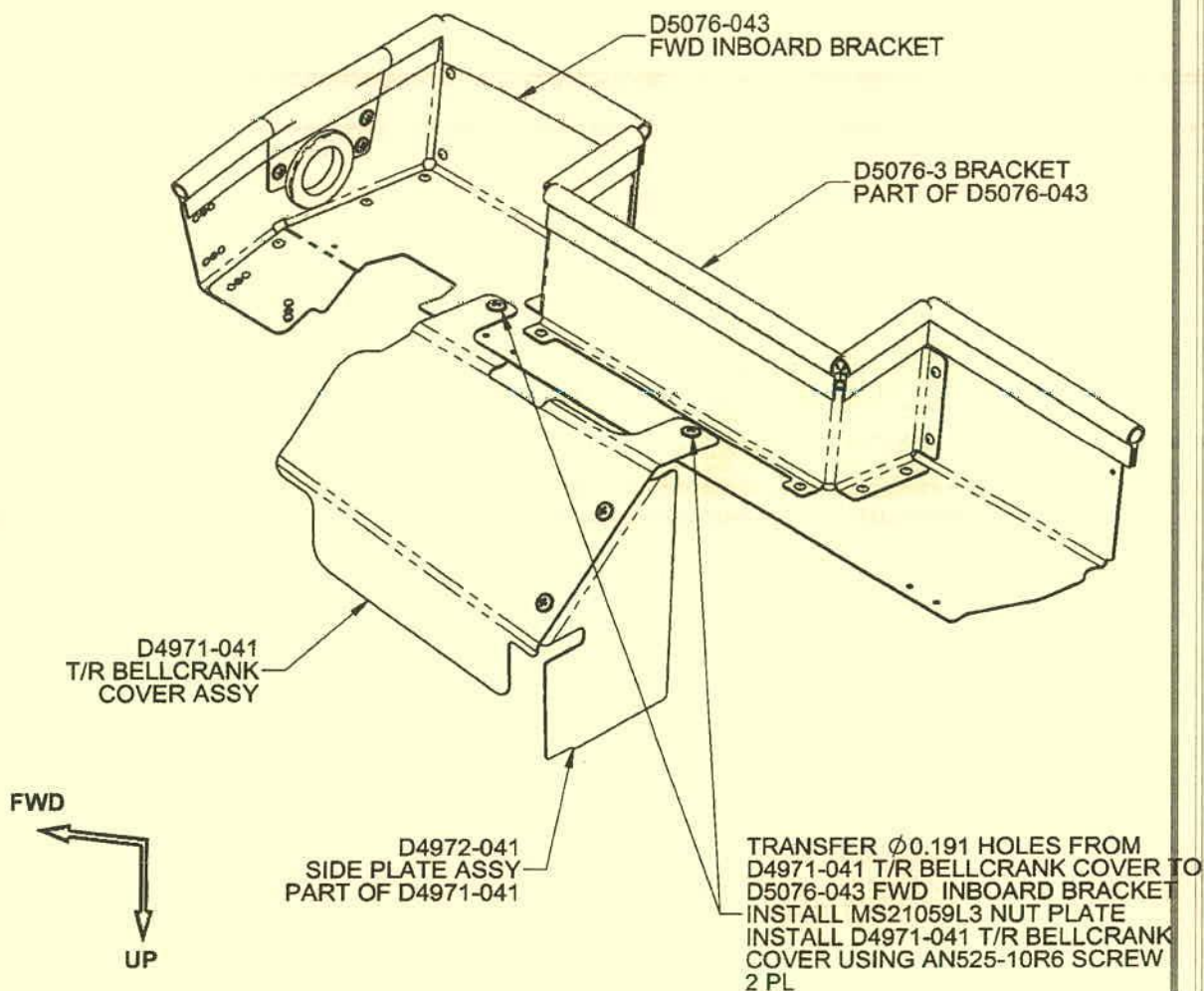


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 18 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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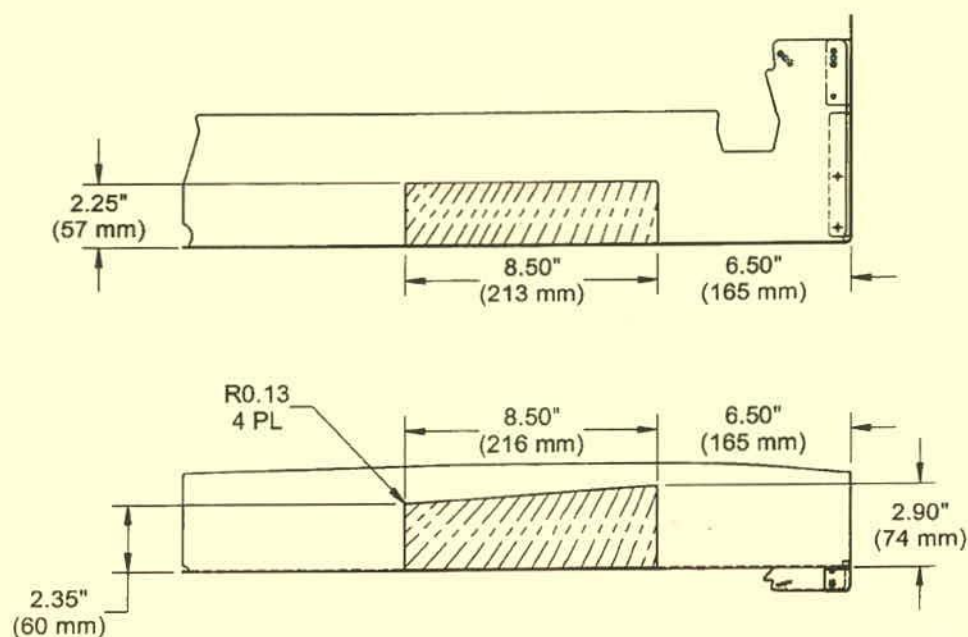
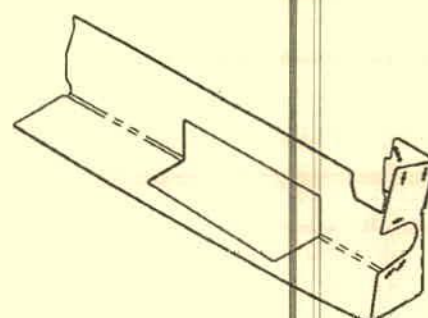


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 19 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Work Order ID 145731

145731

Page 1

Friday, May 06, 2016 10:44:07 AM

Item ID: D350-567-141 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Floor Window Close Out

Start Date: 5/11/2016 Start Qty: 2.00 *2* Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: PM Date: 16/05/09 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DS19590	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USD or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHC004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAY 30 2016

MJ MAY 30 2016

②